

# Work Order ID 53586

November 9, 2009 11:21:30 AM



Page 1

Item ID: D3471-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Stiffener

Start Date: 09/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:   *PS*  

Date: 09/11/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3471

Rev A

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut part as per dwg D3471

*PS 09/11/16* (4)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr 2-Bend as per dwg D3471

*PS 09/11/16*

*4*

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*PS 09/11/16*

(78)

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Page 2

Item ID: D3471-5

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Stop



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Start Date: 09/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

JS 09/11/17

(X4)

Ø



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

DK 09-11-17

(4)



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 178

0.00



Packaging

Memo

0.00

9/11/17 SP

(4) SD

Packaging

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Page 3

Item ID: D3471-5

Accept



Setup Start



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Stop



Item Name: Stiffener

Start Date: 09/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/18 *[Signature]*  
MF 09-11-18

# Picklist Print

November 9, 2009 11:21:34 AM

Page 1

Work Order ID: 53586

Parent Item: D3471-5RevA

Parent Item Name: Stiffener

Comments:

Start Date: 09/11/2009

Required Date: 13/11/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	45.0396	0.4168			

2024-T3 .063 sheet

0.032"

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	45.03962419	
102942	1.5	
105916	3.69	
106223	1.47	
109463	0.00947368	
110980	5.4854	
111787	30.8847505	
19059	2	

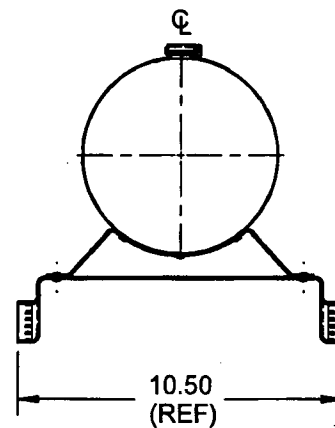
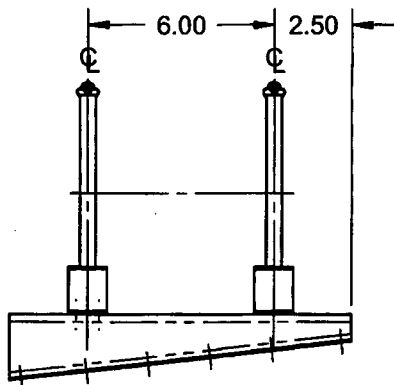
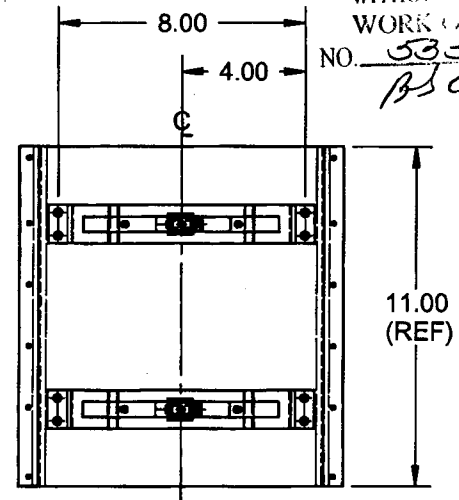
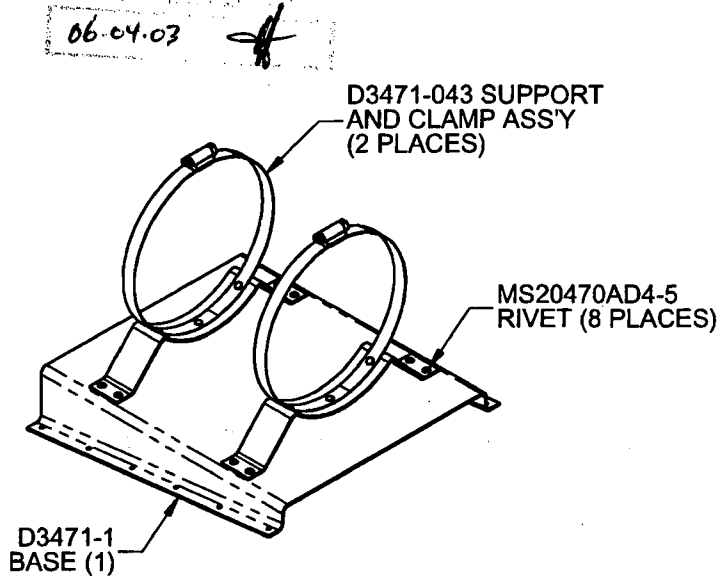
M109240

9/30/11/16

Nov 11/16  
M109240  
2024 T3 .063 sheet  
0.032"



DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>B</i>	DRAWING NO. <b>D3471</b>	REV. A SHEET 1 OF 5
DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:6
A	05.12.21	NEW ISSUE	



### D3471-041 BLOWER MOTOR SUPPORT

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3471-041	BLOWER MOTOR SUPPORT
2	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-1	BASE
8	MS20470AD4-5	RIVET

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3471	REV. A SHEET 2 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:3

06.04.03 *[Signature]*

w/o 53586

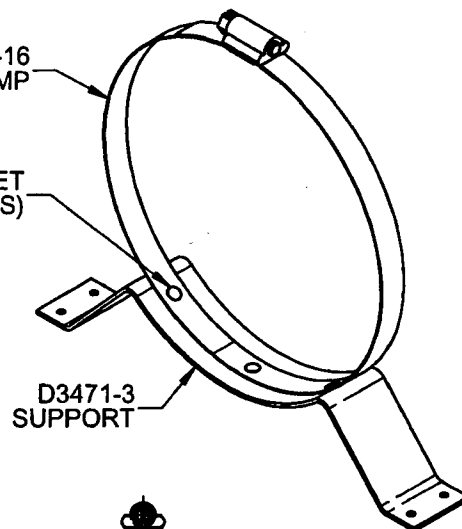
LOCATE AND TRANSFER DRILL  
#30 ( $\phi 0.129$ ) THRU HOLE FROM  
D3471-3 TO MS35842-16 CLAMP  
AND C'SINK  $\phi 0.230 \times 100^\circ$   
(3 PLACES)



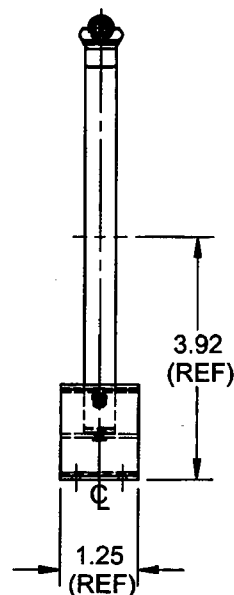
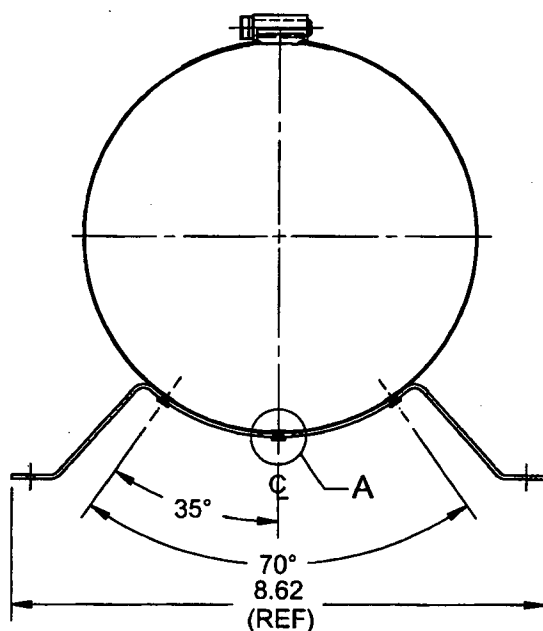
**DETAIL A: COUNTERSINK HOLES**  
(RIVET NOT SHOWN FOR CLARITY)  
SCALE 1:1

MS20427M4-4 RIVET  
(3 PLACES)

MS35842-16  
CLAMP



D3471-3  
SUPPORT



### D3471-043 SUPPORT & CLAMP ASS'Y

#### NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-3	SUPPORT
3	MS20427M-4	RIVET
1	MS35842-16	CLAMP

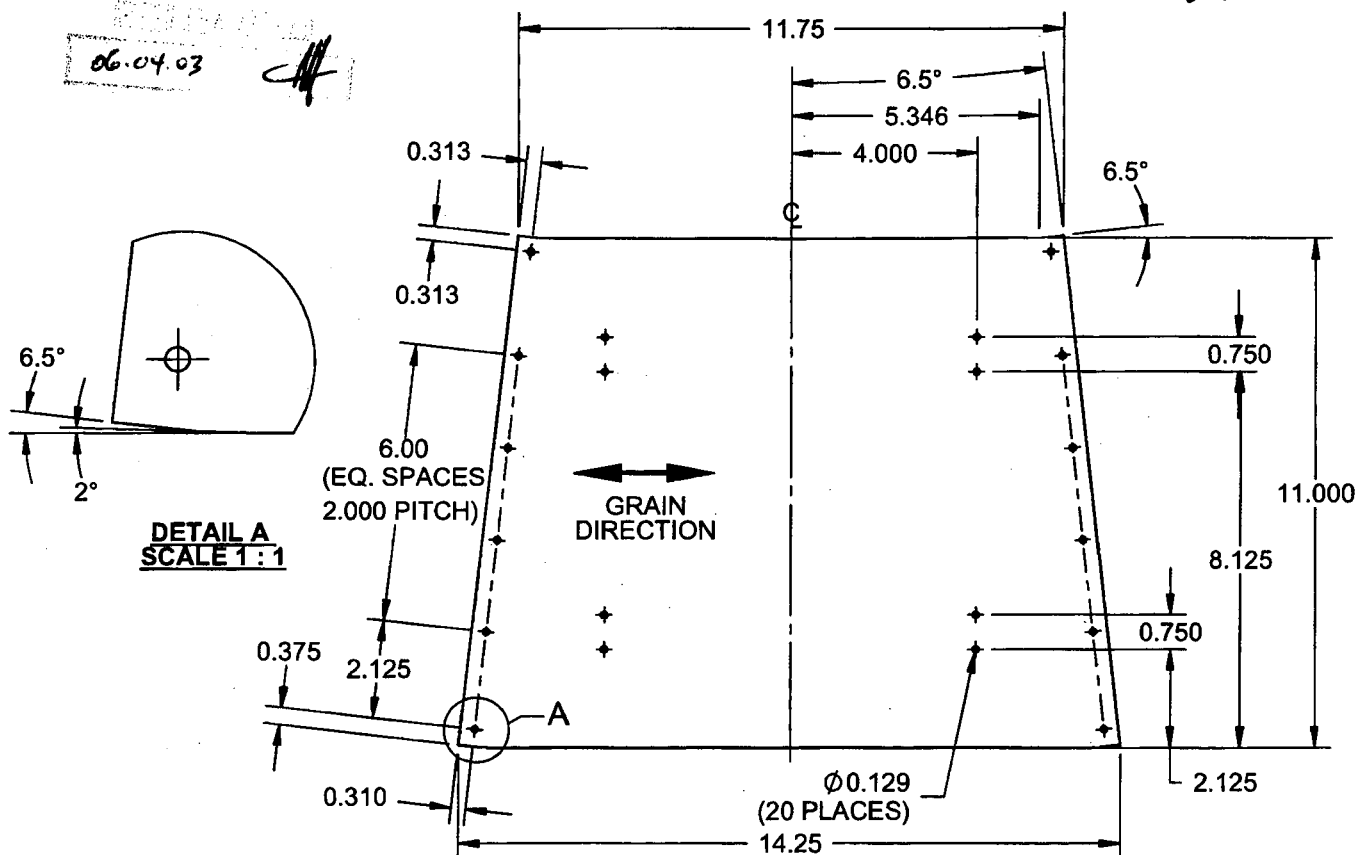
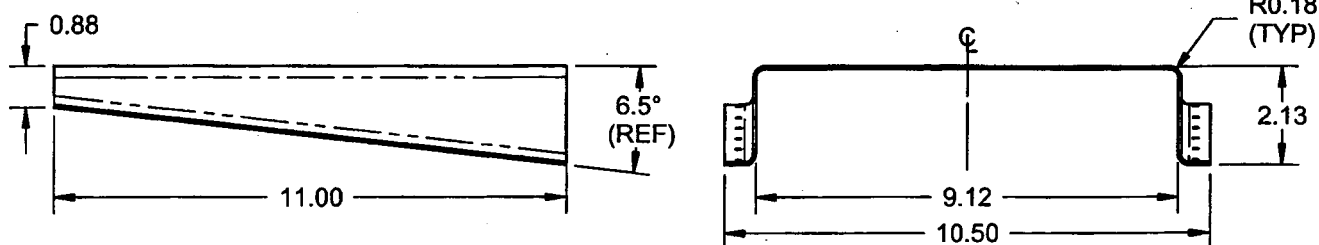
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**DART**

DESIGN #	DRAWN BY #	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3471</b>	REV. A SHEET 3 OF 5
DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:4

w/053586

**D3471-1F BASE FLAT PATTERN****D3471-1 BASE BENDING DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

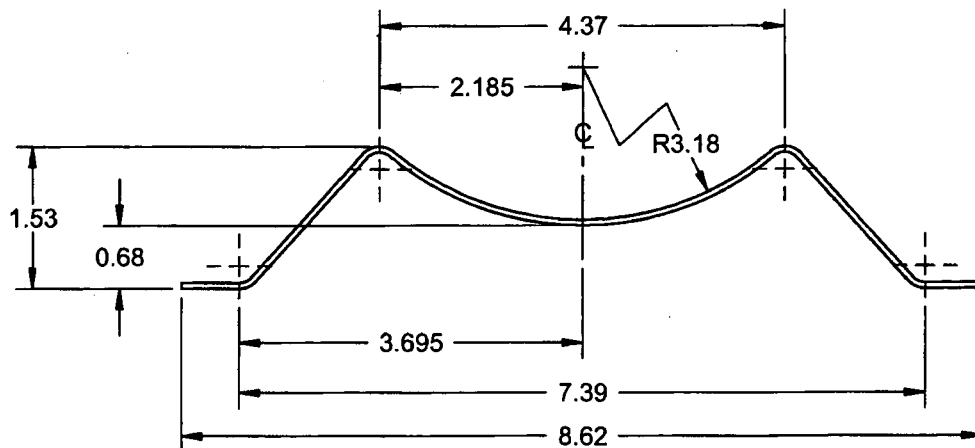
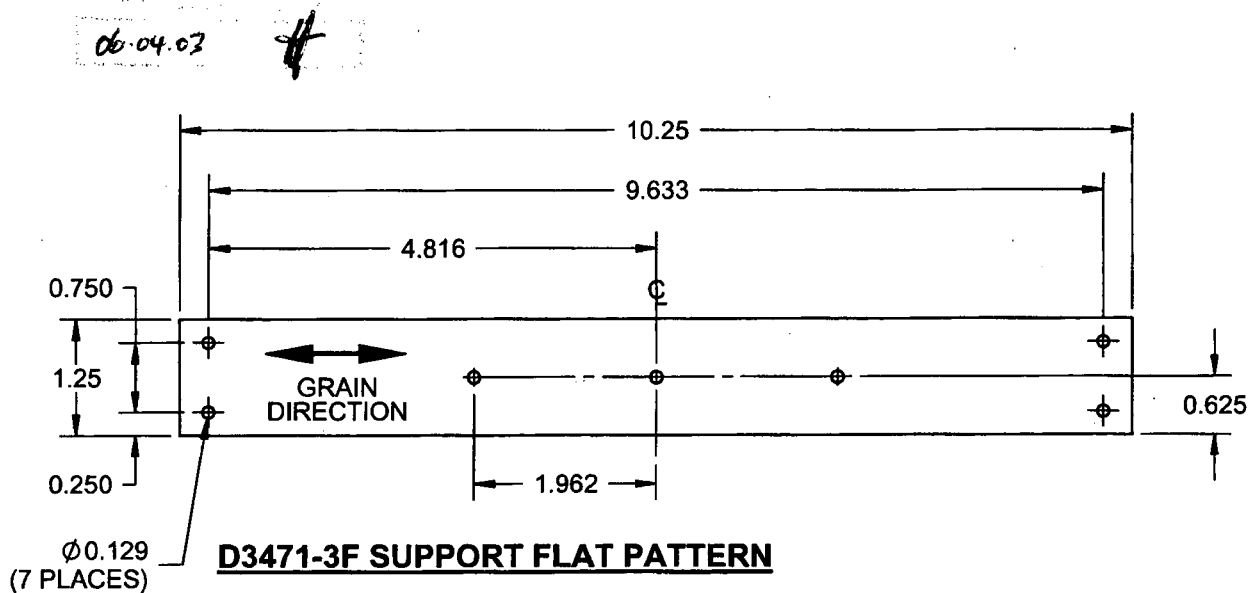
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3471	REV. A SHEET 4 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:2

w/o 53586



### **D3471-3 SUPPORT BENDING DETAIL**

#### **NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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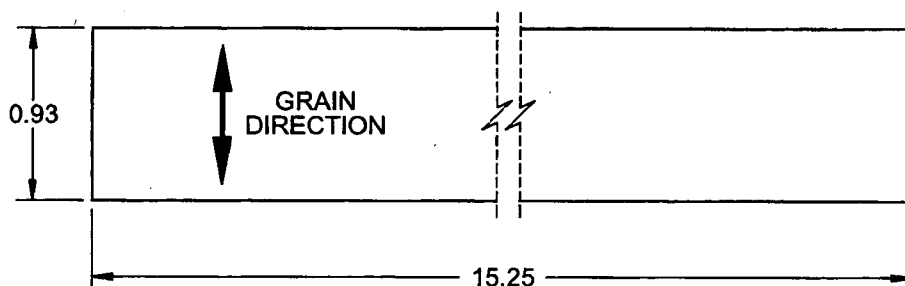




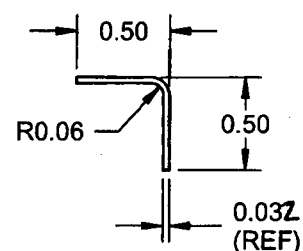
DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. <b>D3471</b>	REV. A SHEET 5 OF 5
DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:1

W/0 53584

06.04.03 *A*



**D3471-5F STIFFENER FLAT PATTERN**



**D3471-5 STIFFENER  
BENDING DETAIL**

**D3471-5 STIFFENER**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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